

Date: Monday, 11/19/2007 4:03:43 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL ASSEMBLY  
 Job Number : 35841  
 Estimate Number : 11005  
 P.O. Number : N/A Part Number : D412704041  
 This Issue : 11/19/2007 S.O. No. : N/A Drawing Number : D412-704-041 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 34230 Material : N/A  
 Due Date : 12/5/2007 Qty: 3 Um: Each  
 Written By :  
 Checked & Approved By : John 11 20  
 Comment : Est Rev:B 05.01.28 Removed hardware on Step 2; Added  
 Figures 1-3 KJ/RF  
 Est Rev:C 06.03.08 Re-format EC  
 Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20  
 JLM  
 Est Rev:E 07.05.02 Reformat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D3204041 Pedal Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch  
 1 D3204-041 Pedal Assembly B35853

AS 07/12/26 (3)

2.0 D32051 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch  
 1 D3205-1 Bracket B30830

No quantities  
 B30830

AS 07/12/27 (3)

3.0 D32053 Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch  
 1 D3205-3 GHW Bracket B32823 x1

take this one out

32823 x3

AS 07/12/27 (3)

4.0 D32061 Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch  
 B29915 x3 B34239 x1

SAH

AS 07/12/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 35841

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3206-1 Pedal arm

5.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3209-.041	Bracket	<u>B30832</u>

*Talk one out*

*AS 07/12/27*

*(X4)*

6.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN3-10A	Bolt	<u>M17566</u>

*AS 07/12/27*

*(X3)*

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN315-4R	Nut	<u>M17566</u>

*AS 07/12/27*

*(X3)*

8.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-10A	Bolt	<u>M104603</u>

*AS 07/12/27*

*(X3)*

9.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	<u>M105143</u>

*AS 07/12/27*

*(X5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 AN4-13A Bolt

106242

AS 12/27 (13)

11.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part number Description batch

5 AN960JD10 Washer

M105792

AS 12/27 (13)

12.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part number Description batch

11 AN960JD416 Washer

105906

AS 12/27 (13)

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part number Description batch

3 AN960JD416L Washer

M105728

AS 12/27 (13)

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description batch

1 MS21042L3 Nut

M10550

AS 12/27 (13)

15.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part number Description batch

5 MS21042L4 Nut

M105054

AS 12/27 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35841

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

AS 12/27 (3)

17.0

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	100290

AS 12/27 (3)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

SAD 08-01-02  
SAD 12-27 (3)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/02 (43)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M104374

8/01/02 SD (3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
17-12-28	180	The D3206-1 arm hits on the D3204-041 petal, resulting in the holes not perfectly lining up. R.C. weld is too big.	<i>[Signature]</i>	2 parts affected. Slightly buff excess weld off of the D3204-041, remove 0.010" off of D3206-1 arm in the affected area only. Touch-up grey per Q51005.	SAD 17-12-28	<i>[Signature]</i> 17-12-28	<i>[Signature]</i>	17-12-28
			<i>[Signature]</i>	<del>Verify fit by Q.C. 31</del>	N/A	<i>[Signature]</i> 17-12-28	<i>[Signature]</i>	
			<i>[Signature]</i>	Touch-up grey per Q51005.	<i>[Signature]</i> 08/01/02	<i>[Signature]</i> 08/01/02	<i>[Signature]</i>	08/01/02
08/01/02	180	one D3206-1 was scrap R.C. was ground too much. Human error	<i>[Signature]</i>	Scrap x1 D3206-1 B29915	SAD 08-01-02	<i>[Signature]</i> 08/01/02	<i>[Signature]</i>	08/01/02

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Seq. #:

Machine Or Operation:

Description :

22.0

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part number Description  
2 AN3-6A Bolt

batch

M106 586

50

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M105558

8/01/03

50 34

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/01/03 (3)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8/01/03

(3)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/01/03

Job Completion



u 8/01/03

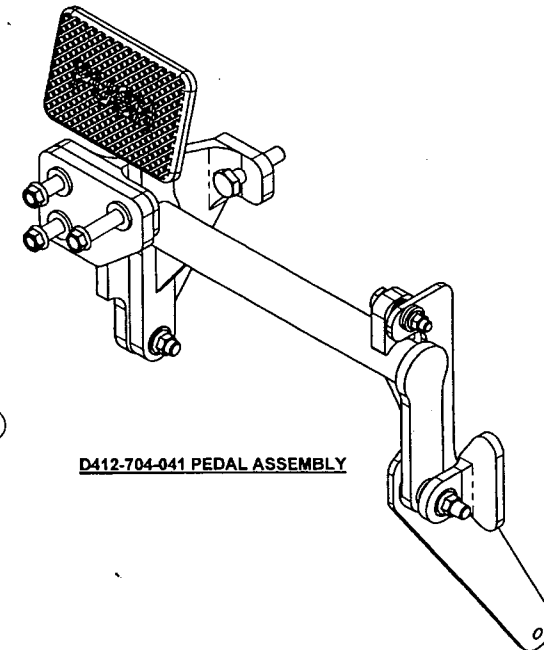
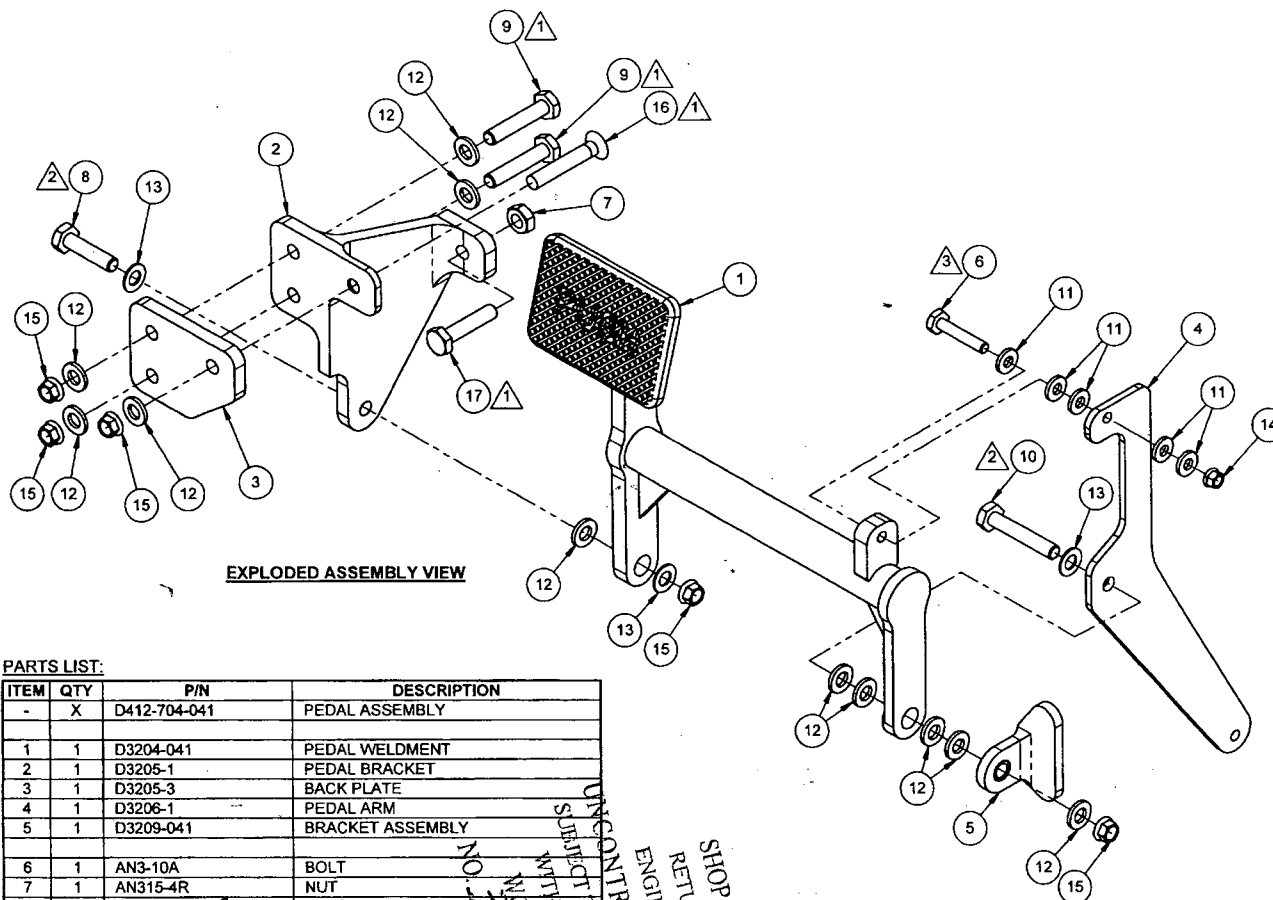
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D412-704-041 PEDAL ASSEMBLY**

**PARTS LIST:**

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

\* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

**NOTES:**

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

**RELEASED**

07.01.20

A	07.01.23	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. <b>D412-704-041</b> REV. A SHEET 1 OF 1
DATE	07.01.23	TITLE <b>PEDAL ASSEMBLY</b> SCALE 1:2
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